

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-014424**Date Inspected:** 21-May-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Yu Dong Ping		
Inspected CWI report:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A

CWI Present:	Yes	No
Rod Oven in Use:	Yes	No
Weld Procedures Followed:	Yes	No
Verified Joint Fit-up:	Yes	No
Approved WPS:	Yes	No
Delayed / Cancelled:	Yes	No

Bridge No: 34-0006**Component:** Tower Components**Summary of Items Observed:**

On this date Caltrans Office of Structural Materials Quality Assurance Inspector, Sandeep Kumar (QA) was present during the times noted above for observations relative to the work being performed.

TOWER TRIAL ASSEMBLY

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No. 005789

Ultrasonic Testing (UT)

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The member is identified as Tower Component. The weld designations reviewed are as follows:

EAST TOWER LIFT – 1 DOUBLER PLATE & CROSS BRACING

P475 – E – 1; 3; 5

BAY#11

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW):

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Weld joint # 9B located on Tower Strut ED1 – STSA4 – 6– 143M – 1. Welder is identified as 044541. ZPMC Quality Control (QC) Inspector is identified as Mao Bin Bin. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2212 – Tc – U5b. (See attached photo)

Weld joint # 9B located on Tower Strut ND1 – STSA4 – 10 – 119M – 2. Welder is identified as 041271. ZPMC Quality Control (QC) Inspector is identified as Mao Bin Bin. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2212 – Tc – U5b.

Weld joint # 7A located on Tower Strut ED1 – STSA4 – 10 – 119M – 1. Welder is identified as 046769. ZPMC Quality Control (QC) Inspector is identified as Mao Bin Bin. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3212 – Tc – U5b – 1.

Flux cored Arc Welding (FCAW):

Weld joint # 29 located on Bearing Stiffener of Shear plate WD1 – A25B/B. Welder is identified as 040723. ZPMC Quality Control (QC) Inspector is identified as Zhao Mao Mao. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2331 – Tc – P4 – F.

Weld joint # 53 located on Bearing Stiffener of Shear plate SD1 – A20B/B. Welder is identified as 053486. ZPMC Quality Control (QC) Inspector is identified as Zhao Mao Mao. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2331 – Tc – P4 – F. (See attached photo)

Weld joint # 21 located on Bearing Stiffener of Shear plate WD1 – A21A/B. Welder is identified as 040726. ZPMC Quality Control (QC) Inspector is identified as Zhao Mao Mao. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2331 – Tc – P4 – F.

BAY#16

This QA Inspector observed the following work in progress:

Flux cored Arc Welding (FCAW):

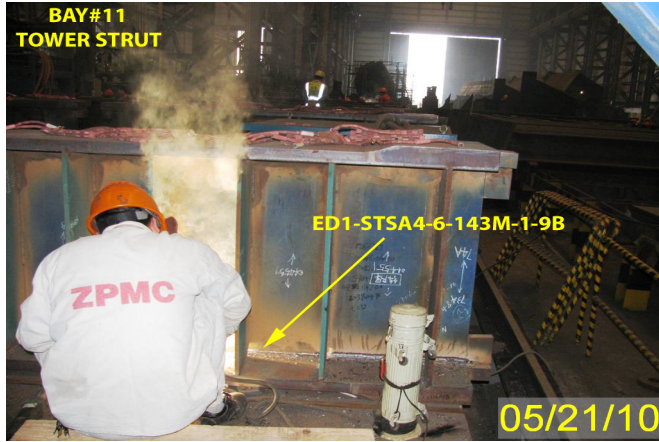
Weld joint # 07 located on Façade built up channel assembly ED1 – SFSA4 – 1703. Welder is identified as 218995. ZPMC Quality Control (QC) Inspector is identified as Wang Hao. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132.

Weld joint # 08 located on Façade built up channel assembly ED1 – SFSA4 – 1700. Welder is identified as 201888. ZPMC Quality Control (QC) Inspector is identified as Wang Hao. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132. (See attached photo)

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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Summary of Conversations:

No Relevant Conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Skyler Guest - 15000422360, who represents the Office of Structural Materials for your project.

Inspected By:	Kumar,Sandeep	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer
